Work Ord September-13-1	er ID 90113 2 1:39:24 PM	3		*901	113*	- 7 M W V V V V V V V V V V V V V V V V V V					Page 1
Item ID: Revision ID: Item Name:	D412-702-311 Harness Assembly		l	Accept	*N900	040	100)* s	Setup Sta	IVI	S1* S2*
Start Date: Required Date: Reference:		tart Qty: 3.00 eq'd Qty: 3.00	*3* *3*		Cust Item l Customer:	D:					
Approvals:		MLJ	Date: 12-09-1			ate:		R	Run Sta Sto		R1* R2*
Sequence ID/ Work Center I	D De	peration escription		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	n Nbr									
ICA-D412-70	2 REV4										
*100 *100* Small Fab Small Fab		Memo Assemble as	per dwg ICA D412-702	0.00 0.00 p.49				3	-		J)12/1
*110 *110* QC	QC	C5- Inspect part compl Memo	eteness to step on W/O	0.00 Sm) 9 23		•	3			-
Quality Control				0.00							
120 Packaging Packaging	13	CHG001	h P/N & CHG# and pack f		0412-702-311		/	6,) [2/k]	25	6/

F . .

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	ONFORM	MANCE / UF		QA Closed:	Date:	
Mork Order	•				DISPOSITION			AGAINST DEF	ARTMENT	/PROCESS	
Work Order: Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator				,							
Material											
Setup											
Other						:					
Process			·								
Supplier										·	
Training								•			
Unapproved											

FAULT CATEGORY Landing Gear General Pressure/Forced Ovalized Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Maintenance Part Moved Cuffs Contamination Countersink Mislabeled Positioned Wrong Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde				*901	13*						Page 2
Revision ID:	D412-702-3			Accept	*N900	040	100)* s	Setup Sta	I Z	S1* S2*
Start Date: Required Date: Reference:	9/07/12 10/12/12	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:					
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		Date:			Run Sta Sto	!//	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control		QC21- Final Inspection •	- Work Order Release	0.00					b	1,0/0	5

N12-10-25

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order					DISPOSITION			AGAINST DEI	PARTMENT	PROCESS	
Work Order: Part No. NCR No.								Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator	_										
Material											
Setup											
Other											
Process											
Supplier			1								

FAULT CATEGORY Landing Gear General Pressure/Forced Grain Ovalized Bend Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Cracks Inspection Incomplete Part Incorrect Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped. Burrs Cuffs Maintenance Part Moved Contamination Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Out of Sequence Finish

Outside Dimensions

Wave/Twist in Tube

Folio

Training Unapproved

Picklist Print September-13-12 1:39:24 PM 90113 Work Order ID: D412-702-311 **Start Date: 9/07/12** Parent Item: Required Date: 10/12/12 Start Qty: 3.00 Required Qty: 3.00 Parent Item Name: Harness Assembly Comments: IPP Rev:A new issue DD 10.04.30 verified:EC Qty per Kit Total Component Item ID/ Unit of Qty on Replacement Mfg/ Bin Primary Last Route **Qty** Date Item Name Location Measure Hand Item ID Seq ID Issued Issued Purch Item Location Qty D3570-1 No Each 1 3 Manufactured Bracket D4088-043 100 Each No Manufactured Shoulder Harness Location Loc Qty Loc Code ST268A 13 13 87352 MS24694-S50 No 100 Each 57.0000 Purchased Screw Location Loc Qty Loc Code ST289 13 116900 118078 119124 ST289A 121166 ST305 43 43 122441 AN960JD10L NAS1149D0332J Purchased 100 Each 0.0000 47 M12 (708 Washer 100 2,768.0000 MS21042L3 Purchased Each Nut

Page 1

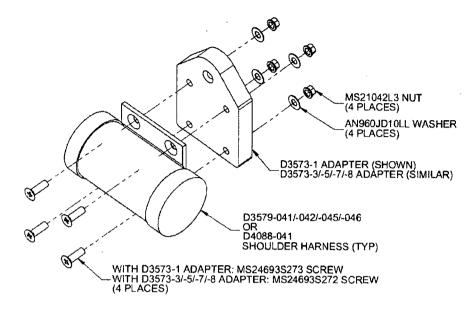
Status

Location		Loc Oty	Loc Code
316		719	
	122452	719	
ST300		581	
	117885	32	
	119017	411	
	119075	138	
ST317		1468	
	122141	1468	

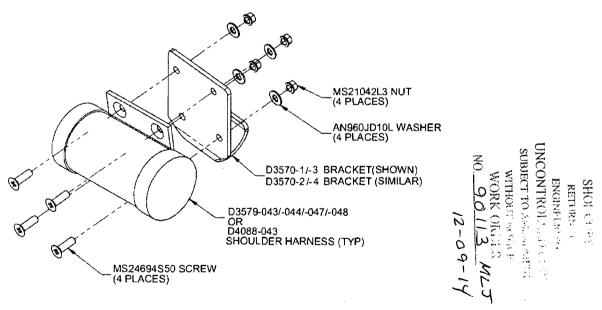
			DQA:	Date:	_
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

								<u></u>	QA Closed:	Date	:	
Work Orde	r:	DISPOSITION				AGAINST DEPARTMENT/PROCESS						
					Rework]	Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.				Scrap	1 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	lo				Work Order Update]	Large Fab	Composite		Supplier		
						_						
Root					ption of work order update	Initial		tion	Sign &	:		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator	_											
Material]										
Setup												
Other												
Process			,									
Supplier												
Training]						
Unapproved							1					
					F.	AULT CATE	GORY					
Landir	ng Gear				General				Ovalized			
	Bending				Bend	Grain	Grain				Pressure/Forced	
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardwa	Hardware			tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct _	Weld	
. [Crushed/Crimped.				Burrs	Instruc	tions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Maint	enance		Part Moved			
ſ	Heat Treat				Countersink	Mislab	eled		Positioned \	Wrong		
ſ	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss,	'Surge	Other	
	Ripples in	Bend			Drill Holes	Offset						
	Torque W	aves in E	xtrusio	n $lacksquare$	Drawing	Out of	Calibration					
	Turning S	equence			Finish	Out of	Sequence					
Ī	Wave/Tw	ist in Tul	oe		Folio	Outside	e Dimensions					





DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B OR -301/-303/-305/-307/-309/-315/-317 HARNESS ASSEMBLIES



DETAIL 'L' D412-702-111A/-111B/-113A/-113B OR -311/-313/-321/-323 HARNESS ASSEMBLIES

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